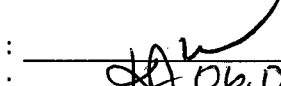
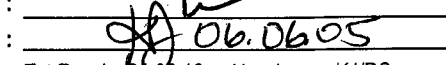


Date: Monday, 6/5/2006 7:31:33 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY
Job Number :	27339		
Estimate Number :	11887		
P.O. Number :	NIA	Part Number :	D3137045
This Issue :	6/5/2006	Drawing Number :	D3137 REV E
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	NIA	Drawing Revision :	E
Previous Run :	25467	Material :	NIA
	Type :	Due Date :	6/30/2006
	MACHINED PARTS	Qty:	6 Um: Each
Written By :			
Checked & Approved By :	 06.06.05		
Comment :	Est Rev:A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M174B0500X02000	17-4 SS Bar
-----	-----------------	-------------



Comment: Qty.: 0.3849 f(s)/Unit Total : 2.3096 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B0.500x02.000)
 Batch: M19572

J.L 06/07/24

6

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: (.500" x 2.000") 4.400" long

J.L 06/07/24

6

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3137-9 as per Folio FA621 and Dwg D3137 Identify as D3137-9

2-Deburr

3-Scribe batch number

J.L 06/07/24

6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06/07/24

6

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 06/07/24

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:31:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27339

Part Number: D3137045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31373

Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-3

GUIDE

B26888

35 B 28149

7.0

D31375

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-5

Washer

B27246

8.0

MS24694S101

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS24694-s101

Screw

B16941

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3137-045 as per Dwg D3137

ml 06/08/09

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-21 (6)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST41P

22 06/08/22

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 04/08/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:31:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27339

Part Number: D3137045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

A 06.08.24

Job Completion



Le 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

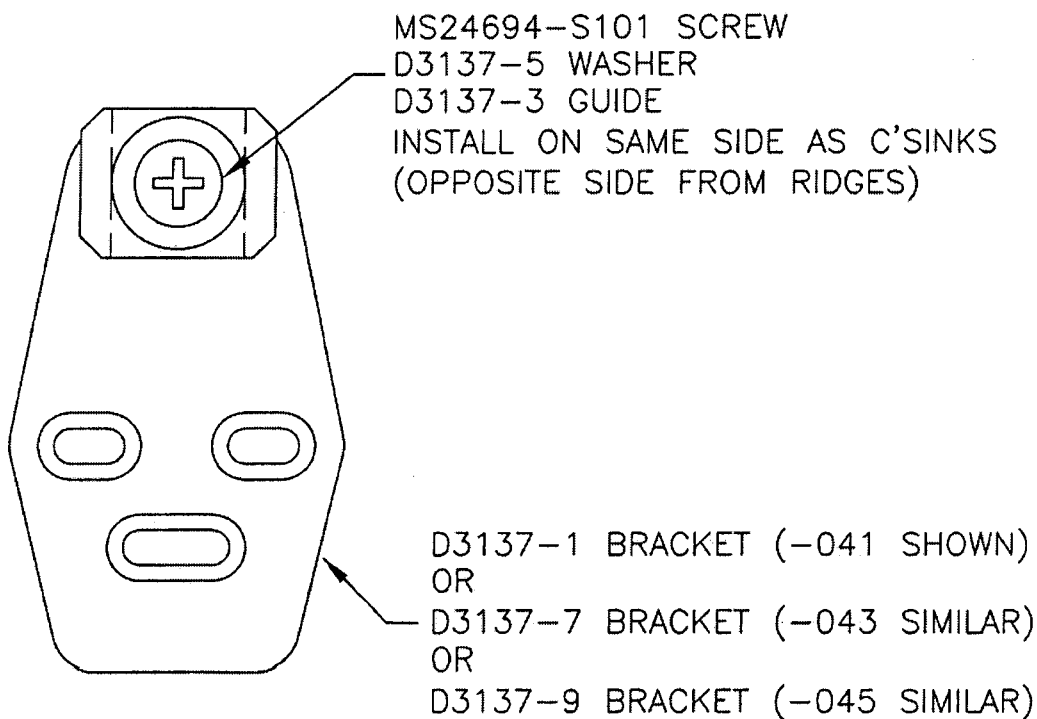
QA: N/C Closed: _____ Date: _____



DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09



D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)
D3137-045 BRACKET ASSEMBLY (SIMILAR)

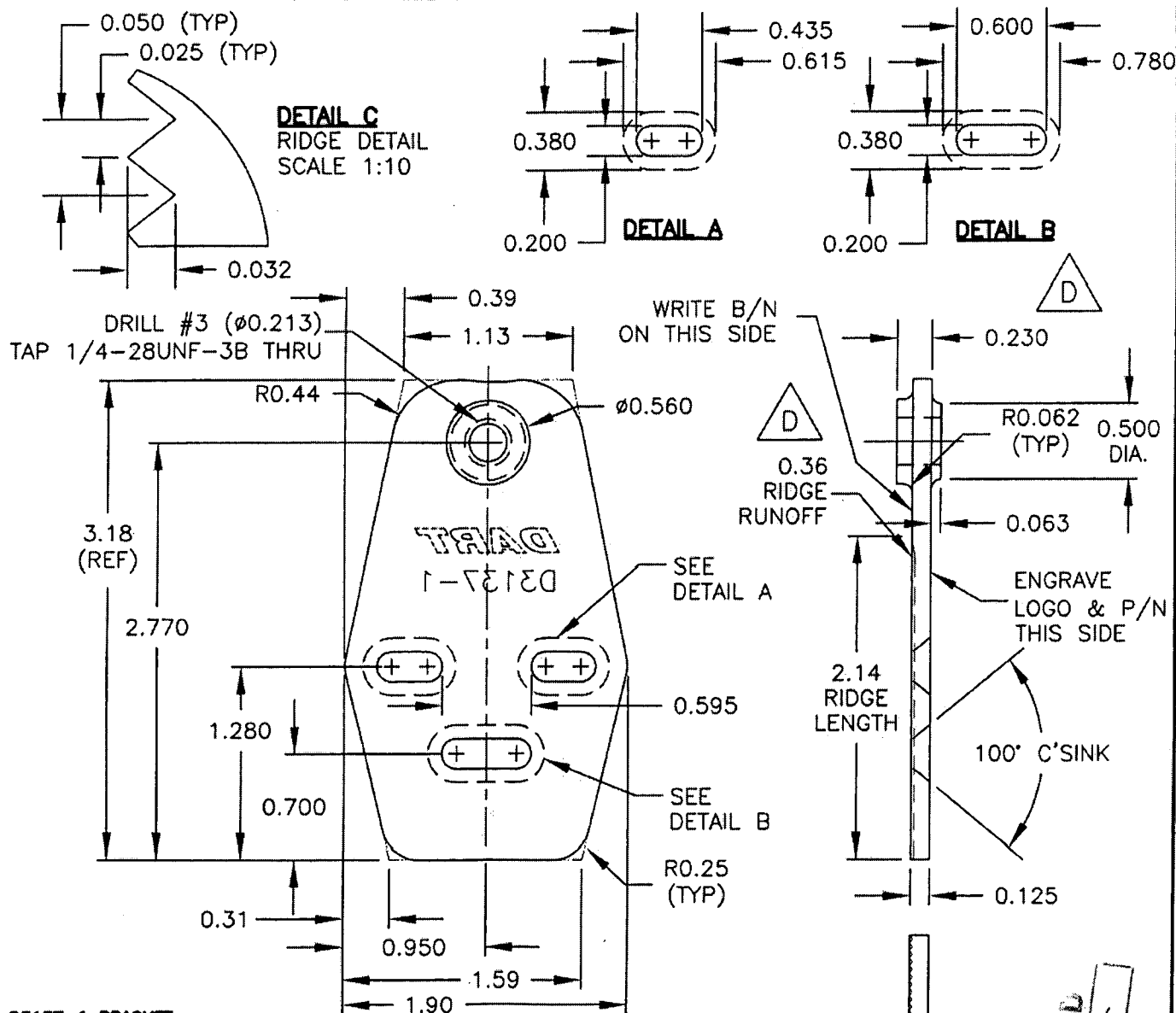
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CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 2 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3137-1 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANET INK MARKER

SEE DETAIL C

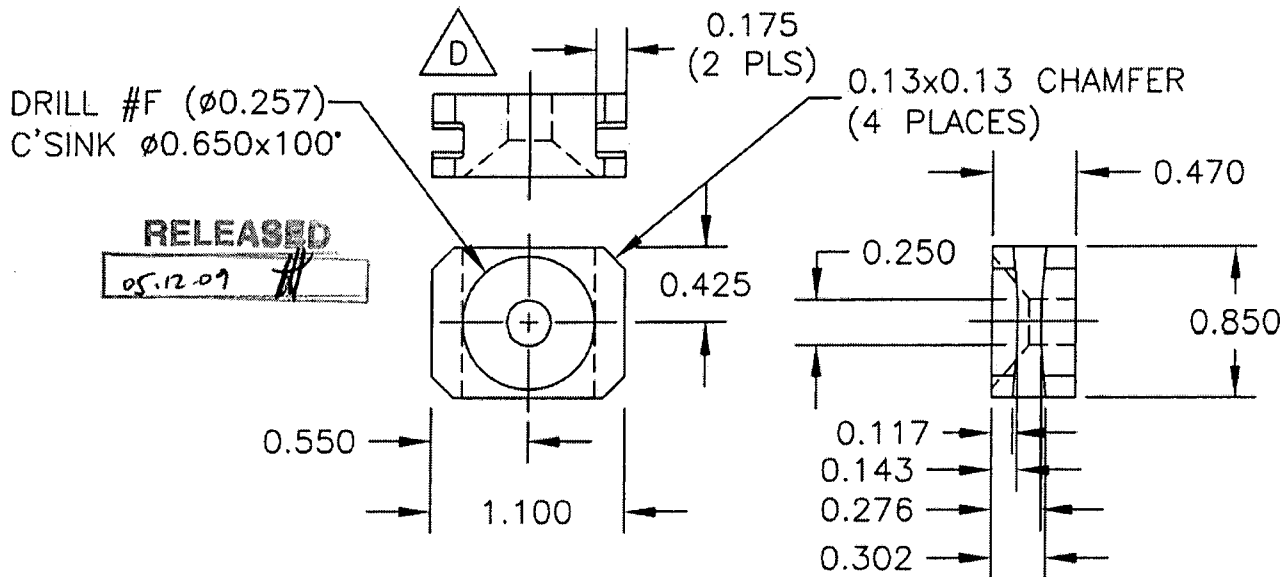
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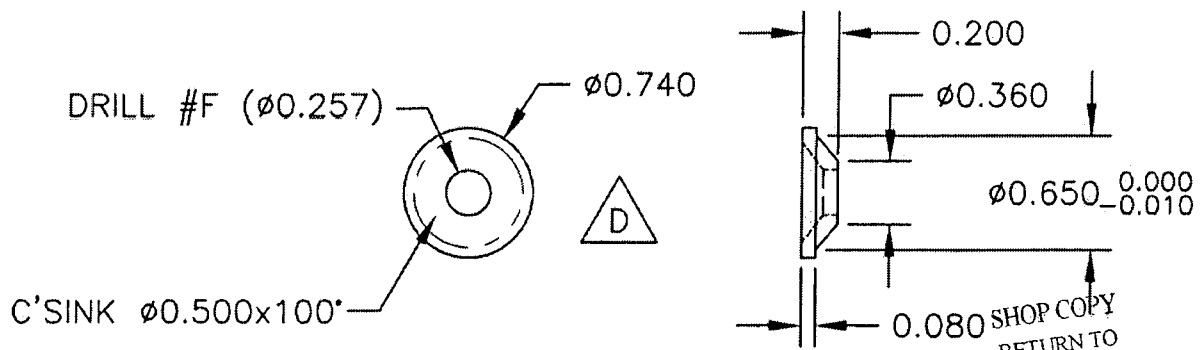
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CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 3 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3137-3 GUIDE**

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

**D3137-5 WASHER**

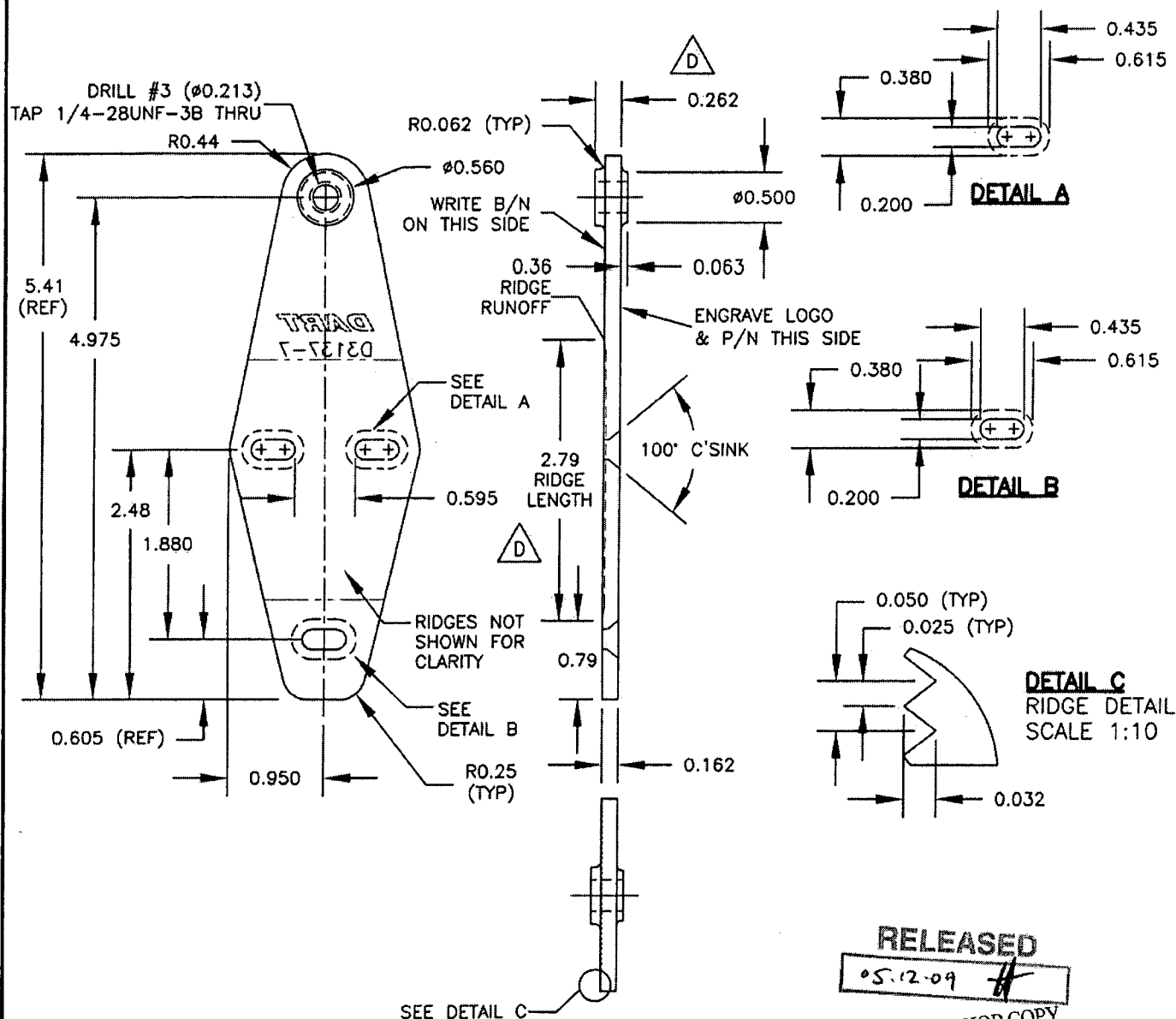
- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 2:3

**03137-7 BRACKET:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

RELEASED05.12.09 *[Signature]*

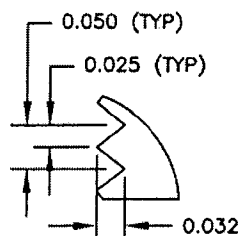
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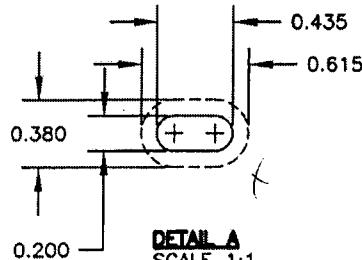
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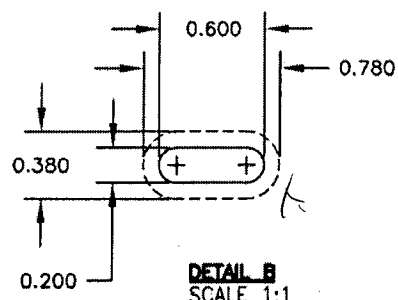
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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:2



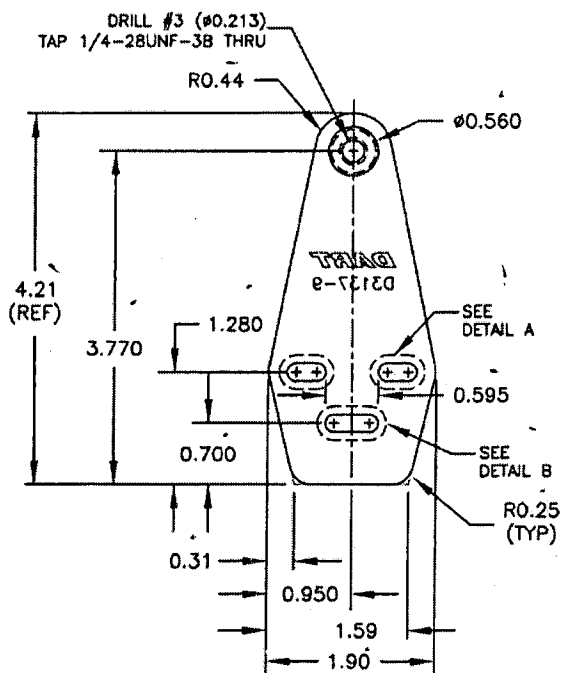
DETAIL C
RIDGE DETAIL
SCALE 1:20



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1



E

D3137-2 BRACKET:

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order: 27339
Description: bracket assembly		Part Number: D3137-9
Inspection Dwg: D3137 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
435	± .010	435	✓			
615	"	620	✓			
380	"	385	✓			
200	"	200	✓			
600	"	600	✓			
780	"	785	✓			
500	"	501	✓			
063	"	062	✓			
1.062	"	1.062	✓			
1162	"	1162	✓			
560	"	561	✓			
595	"	595	✓			
4.21	± .030	4.210	✓			
3.770	± .010	3.770	✓			
1280	"	1280	✓			
700	"	700	✓			
190	± .030	1.893	✓			
100°	1	100°	✓			
2.14	± .030	2.150	✓			
262	± .010	262	✓			
1.25		25	✓			
032	± .010	032	✓			

Measured by: J.L.
Date: 06/07/24

Audited by: En
Date: 06/07/24

Prototype Approval: N/A
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	